

Work Order ID 109967

December-10-13 7:25:09 AM

D 3 2 9 5 - 0 4
B 1 0 9 9 6 7

109967

Page 1

Item ID: D3295-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacment Interior Window For -111

Start Date: 12/10/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/11/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3295	E								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

***ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING
PARTS***

1-Cut D3295-1 as per Dwg D3295

Dwg Rev: E

Prog Rev: E

2-Remove plastic and wrap in saran wrap.

3-Deburr if necessary

8

0

De
13.12.10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8

0

De
13.12.10

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Page 2

Item ID: D3295-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacment Interior Window For -111
 Start Date: 12/10/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 12/11/13 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 9-89 13/12/11				8			
130 *130* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3295. Put window in plastic wrap.	0.00 DAS 27 9-89 13/12/11				8x			13/12/11
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 13/12/11				8			

DAS
36
9-89

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Item ID: D3295-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacment Interior Window For -111

Start Date: 12/10/13 Start Qty: 8.00 *8* Cust Item ID:


Required Date: 12/11/13 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST212</u>	0.00							
150									
Packaging	Memo	0.00				8X	DAS 28	13-12-16	
Packaging							9-89		
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13/12/18 

CL 13/12/18

Picklist Print

December-10-13 7:25:09 AM

Page 1

Work Order ID: 109967

Parent Item: D3295-041

Parent Item Name: Replacment Interior Window For -111

Start Date: 12/10/13

Required Date: 12/11/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1 Dart Logo Label Small		Manufactured	No			140	Each	1.0000	0	0		12/13/12/11	
MLEXS.125-9034-01 1/8" 9034 Lexan Sheet		Purchased	No			100	sf	120.5100	1.24	11		12/13/12/10	

Location

Loc Qty

Loc Code

MAT019

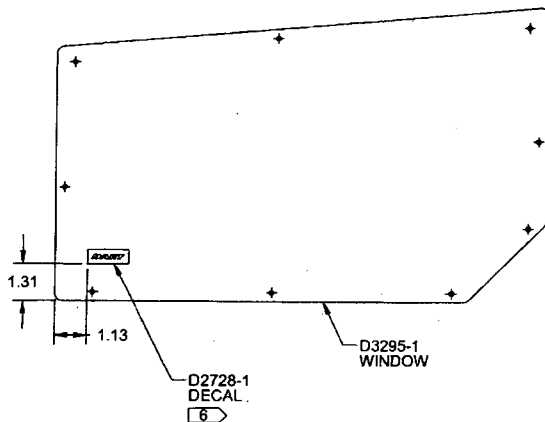
120.51

125052

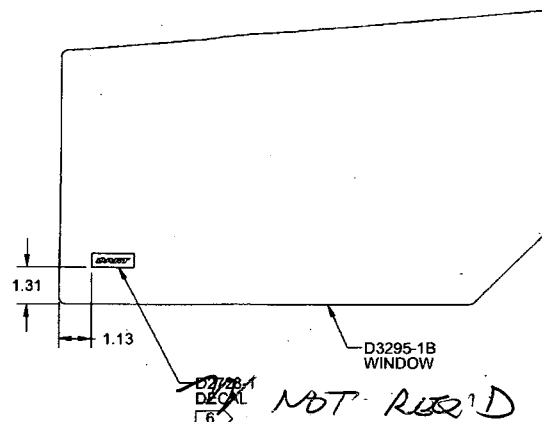
120.51

125052 → 11.00

ITEM	QTY -041	QTY -041B	P/N	DESCRIPTION
	X		D3295-041	FLOOR WINDOW
		X	D3295-041B	FLOOR WINDOW, BLANK
1	1		D3295-1	WINDOW
2		1	D3295-1B	WINDOW, BLANK
3	1	1	D2728-1	DECAL



D3295-041 FLOOR WINDOW



D3295-041B FLOOR WINDOW, BLANK

NOT RECD 13/12/11

109967

RELEASED
2012-11-21

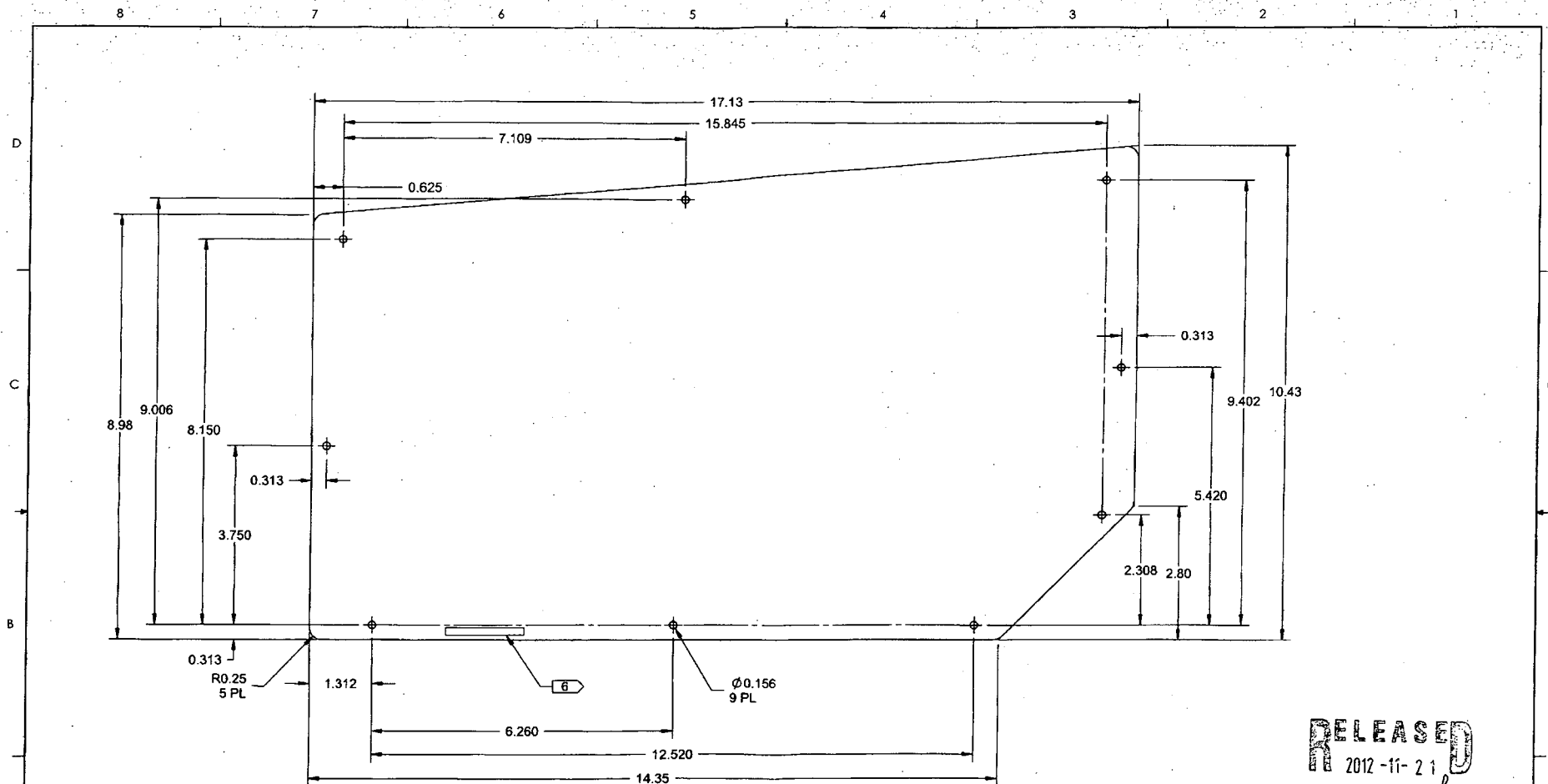
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) N/A
 - 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
 - 7) WEIGHT: D3295-041/-041B = 0.87 lbs

REV.	DESCRIPTION	BY	DATE
E	ADD D3295-041B-1B. REF. PAR12-223.	MB	12.11.15
D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.05.28
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3295
SHEET 1 OF 3
TITLE FLOOR WINDOW
SCALE NTS

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D3295-1 WINDOW

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3295	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW	NTS
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8 7 6 5 4 3 2 1

D

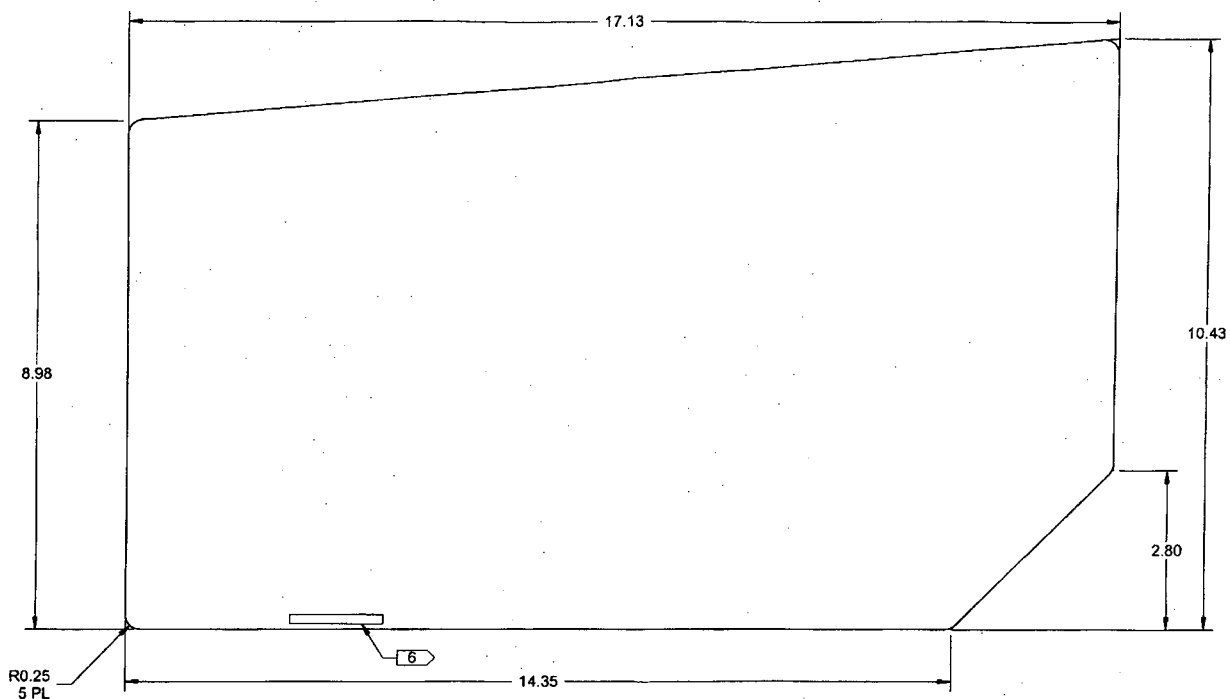
D

C

C

B

B



D3295-1B WINDOW

RELEASED
2012-11-21
JMP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041B" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN.
- 7) WEIGHT: 0.87 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3295	REV. E
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE FLOOR WINDOW	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 109967
Description: Replacement INTERIOR WINDOW		Part Number: D3295-041
Inspection Dwg: 3295 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.13	+/- .030	17.13	-		T	JKm-06
15.845	+/- .010	15.845	-		T	
7.109	+/- .010	7.109	-		T	
.625	+/- .010	.625	-		V	JKm-05
9.006	+/- .010	9.006	-		T	
8.150	+/- .010	8.150	-		T	
8.98	+/- .030	8.98	-		T	
3.750	+/- .010	3.750	-		T	
.313	+/- .010	.313	-		V	
.313	+/- .010	.313	-		V	
14.35	+/- .030	14.35	-		T	
12.520	+/- .010	12.520	-		T	
6.260	+/- .010	6.260	-		T	
1.312	+/- .010	1.312	-		V	
10.43	+/- .030	10.43	-		T	
9.402	+/- .010	9.402	-		T	
5.420	+/- .010	5.420	-		T	
2.308	+/- .010	2.308	-		T	
2.80	+/- .030	2.80	-		T	
.313	+/- .010	.313	-		V	
Ø .156	+ .005 / - .001	.156	-		V	

Measured by: <i>AE</i>	Audited by: <i>DAS</i> 27 0.80	Preliminary Approval:
Date: 13.12.10	Date: 13.12.11	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15